

Sheet 70074

Dart Aerospace Ltd.

Date: Tuesday, 07/10/2008 1:02:38 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SS WEARSHOE KITS
Job Number : 42499	
Estimate Number : 12802	
P.O. Number :	Part Number : DS19367011
This Issue : 07/10/2008 S.O. No. :	Drawing Number : DS19367 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 40407	Material :
Written By :	Due Date : 07/10/2008 Qty: 2 Um: Each
Checked & Approved By : <u>JLD 08.10.07</u>	
Comment : Est Rev:A New Issue 07-03-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.10.07



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPDS19367-011 CHG 001

508/10/07

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D35641	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

WEARSHOE

Batch: B40958

sq

4.0	D35661	Gasket
-----	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

GASKET

Batch: B41915

sq

5.0	D35643	Wearshoe
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

WEARSHOE

Batch: B33801

8/10/07

(2x)

sq

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/10/2008 1:02:38 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SS WEARSHOE KITS

Job Number: 42499

Part Number: DSI9367011

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

D35645

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

WEARSHOE

Batch: B41464 x1, 41145 x1

SP

7.0

D35665

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

GASKET

Batch: 41467

SP

8.0

AN3C4A

BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total: 48.0000 Each(s)

BOLT

Batch: M108599

SP

9.0

AN3C6A

BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

BOLT

Batch: M108880

SP

10.0

AN3C7A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

BOLT

Batch: M105906

SP

11.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total: 88.0000 Each(s)

washer

Batch: M109282

01/10/07

SP

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/10/07 (F2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SS WEARSHOE KITS

Job Number: 42499

Part Number: DSI9367011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



(3x)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Dsi9367-011

Location: _____

PPP Rev: _____

A

8/10/07

59

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/07

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-10-07

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9367	REV. A SHEET 1 OF 3
DATE 07.02.09		TITLE STAINLESS STEEL WEARSHOE KITS SCALE NTS	
A	07.02.09	NEW ISSUE	

DART SERVICE INSTRUCTION
TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. B
REF. FAA STC: SR01583SE
REF. CANADIAN STC: SH05-37 ISSUE 1

For customers with D412-742-011/-013 float skid tubes at CHG 002 or earlier who would like to upgrade to stainless steel wearshoes the following kit can be obtained from Dart:

QTY -011	Part Number	Description
X	DSI 9367-011	WEARSHOE KIT
1	D3564-1	WEARSHOE (REPLACES D3460-1)
2	D3566-1	GASKET
1	D3564-3	WEARSHOE (REPLACES D3460-3)
1	D3564-5	WEARSHOE (REPLACES D2577-5)
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

For customers with D412-742-011/-013 float skid tubes at CHG 002 or earlier who would like to upgrade the fwd and aft sections of their float skid tubes, the following kits can be obtained from Dart:

QTY -013	Part Number	Description
X	DSI 9367-013	WEARSHOE KIT
1	D3564-13	WEARSHOE
1	D3566-13	GASKET
1	D3537-1	WEARPAD
1	D3553-1	GASKET
1	D3537-7	WEARPAD
1	D3553-3	GASKET
10	NAS1330C3KB166	INSERT
4	NAS1330C3KB266	INSERT
10	AN3C4A	BOLT
4	AN3C5A	BOLT
14	AN960C10L	WASHER

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

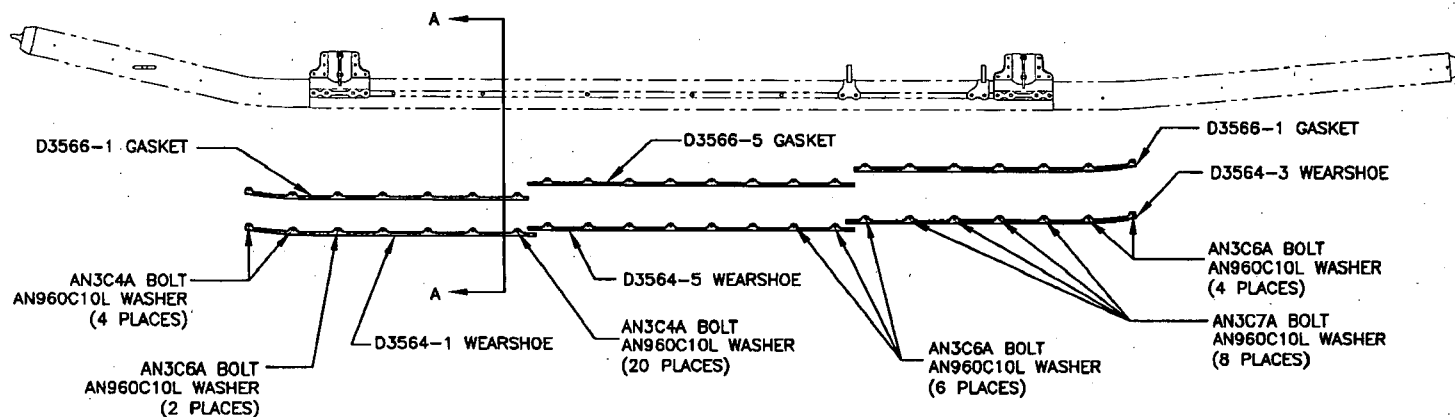
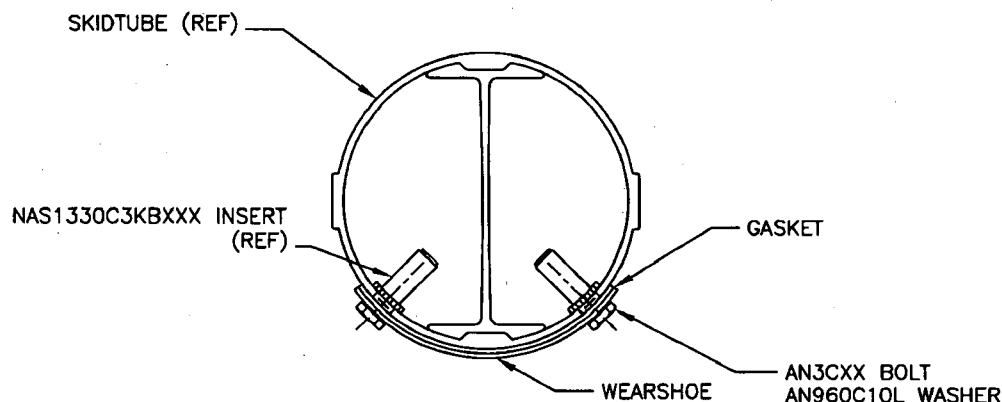


FIGURE 1: DSI 9367-011 WEARSHOE KIT



SECTION A-A
(TYPICAL INSTALLATION)

DSI 9367-011 Wearshoe Kit Installation Procedure

- 1) Remove skidtube from aircraft per Section 32.1 of ICA-D412-742.
- 2) Remove existing D3460-1/-3 and D2577-5 wearshoes by removing AN3C hardware. Begin wearshoe removal from the fwd end of the skidtube towards the aft end.
Note: Removing the wearshoes will require breaking a layer of sealant between the wearplates and the skidtube.
Clean residual sealant off the bottom of the skidtube. Check for corrosion and mechanical damage in accordance with Chapter 5 of ICA-D412-742 and repair as required.
- 3) Install D3564-1/-3/-5 wearshoes complete with D3566-1/-5 gaskets using AN3C bolts beginning from the aft end of the skidtube and install towards the fwd end of the skidtube as shown in Figure 1. Seal all bolts with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing. Torque bolts to 15-25 in-lbs (1.7-2.8 N-m).
- 4) Re-install skidtube on aircraft per Section 32.2 of ICA-D412-742.

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	07.02.09	TITLE	DSI 9367	REV. A
			STAINLESS STEEL WEARSHOE KITS	SHEET 2 OF 3
				SCALE
				NTS

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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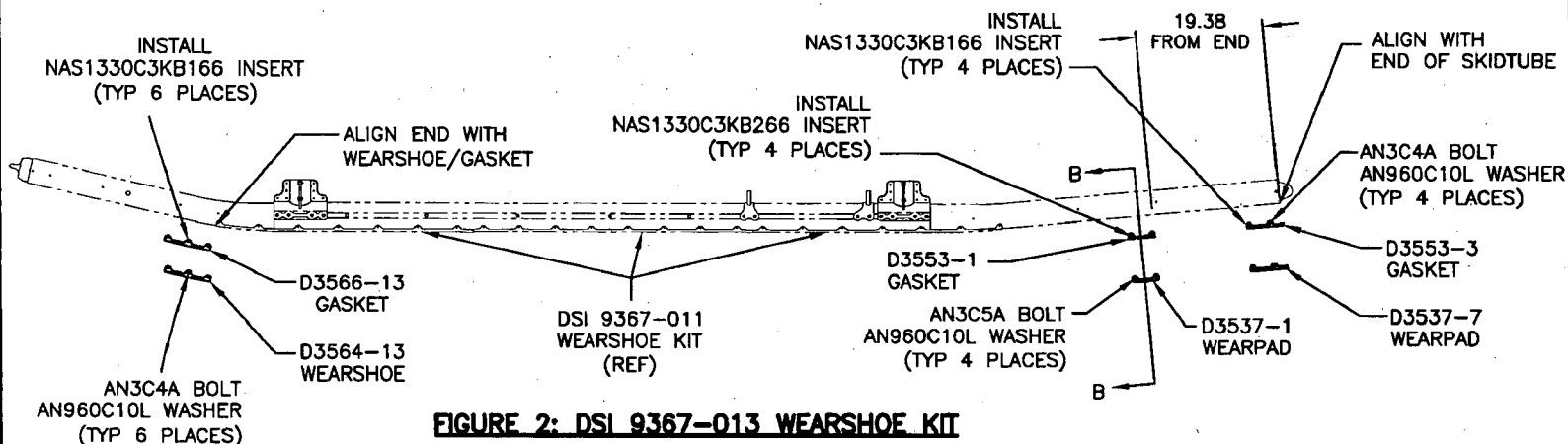
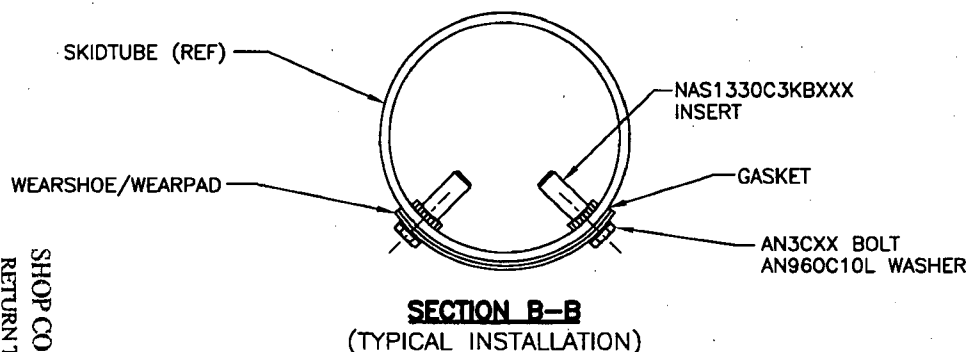


FIGURE 2: DSI 9367-013 WEARSHOE KIT



**SECTION B-B
(TYPICAL INSTALLATION)**

DSI 9367-013 Wearshoe Kit Installation Procedure

- 1) Remove skidtube from aircraft per Section 32.1 of ICA-D412-742.
- 2) Check skidtube for corrosion and mechanical damage in accordance with Chapter 5 of ICA-D412-742 and repair as required.
- 3) Locate the wearshoe/wearpads and gaskets as shown in Figure 2.
- 4) Using the wearshoe/wearpad/gasket as a template, drill $\varnothing 0.125$ " holes in the center of the wearshoe/wearpad obrounds. Remove the wearshoe/wearpad/gasket and drill qty (14) $\varnothing 0.250$ " - $\varnothing 0.257$ " holes for installing the required inserts, countersink all holes to $\varnothing 0.391 \times 100^\circ$. Deburr and remove swarf from inside of skidtube.
- 5) Touch up holes with chemical film material (Alodine 1200/1201) per MIL-C-5541 and one coat of MIL-P-85582 or MIL-P-23377 primer. Install NAS1330C3KB inserts using Sikaflex -241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant prior to installation.
- 6) Install D3564-13 wearshoes and D3537-1/-7 wearpads complete with D3566-13 and D3553-1/-3 gaskets using AN3C bolts as applicable. All bolts should be sealed with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing. Torque bolts 15-25 in-lbs (1.7-2.8 N-m).
- 7) Re-install skidtube on aircraft per Section 32.2 of ICA-D412-742.

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CHECKED	GH	APPROVED	GH	
DATE	07.02.09	DRAWING NO.	DSI 9367	REV. A
		TITLE	STAINLESS STEEL WEARSHOE KITS	SHEET 3 OF 3
		SCALE	NTS	

W/O:		WORK ORDER CHANGES					
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